

5/03

DART AEROSPACE LTD	Work Order :	Z2009
Description: LUG BRACKET	Part Number:	D2735-1
Drawing: D2735 REV. B <i>PC DM 99.08.09</i>	Qty:	54 <i>50</i>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	<i>HA</i>	<i>04.12.01</i>	<i>50</i>
2	PURCHASING	Issue P/O: <i>1007232</i> Make per Drawing D2735 Material release note required	<i>U</i>	<i>04-12-06</i>	<i>50</i>
3	RECEIVING	Receive and Inspect for transit damage Ensure the material release note attached	<i>CL</i>	<i>04/12/15</i>	<i>50</i>
4	QC	Level 6 inspection per Master part Dwg and QSP 019	<i>U</i>	<i>04-12-06</i>	<i>50</i>
5	METAL	Bend per Drawing D2735 Use CNC Brake Jig DT8204	<i>Z</i>	<i>05.01.11</i>	<i>54</i>
6	QC	Inspect Level 5	<i>M</i>	<i>05/01/12</i>	<i>54</i>
7	STORES	Identify and Stock	<i>CL</i>	<i>05/01/12</i>	<i>54</i>
8	EXPEDITING	Close W/O Cost / part <i>4.90</i> <i>545</i> <i>05/01/13</i> <i>(54)</i> <i>5.09</i>	<i>HA</i>	<i>05.01.14</i>	<i>54</i>

Rev	Date	Change	Revised By	Approved
A	98.01.19	New Issue	BW	
B	98.11.16	Re-format, Changed steps	DM	<i>PS</i>

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
DM 99.08.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

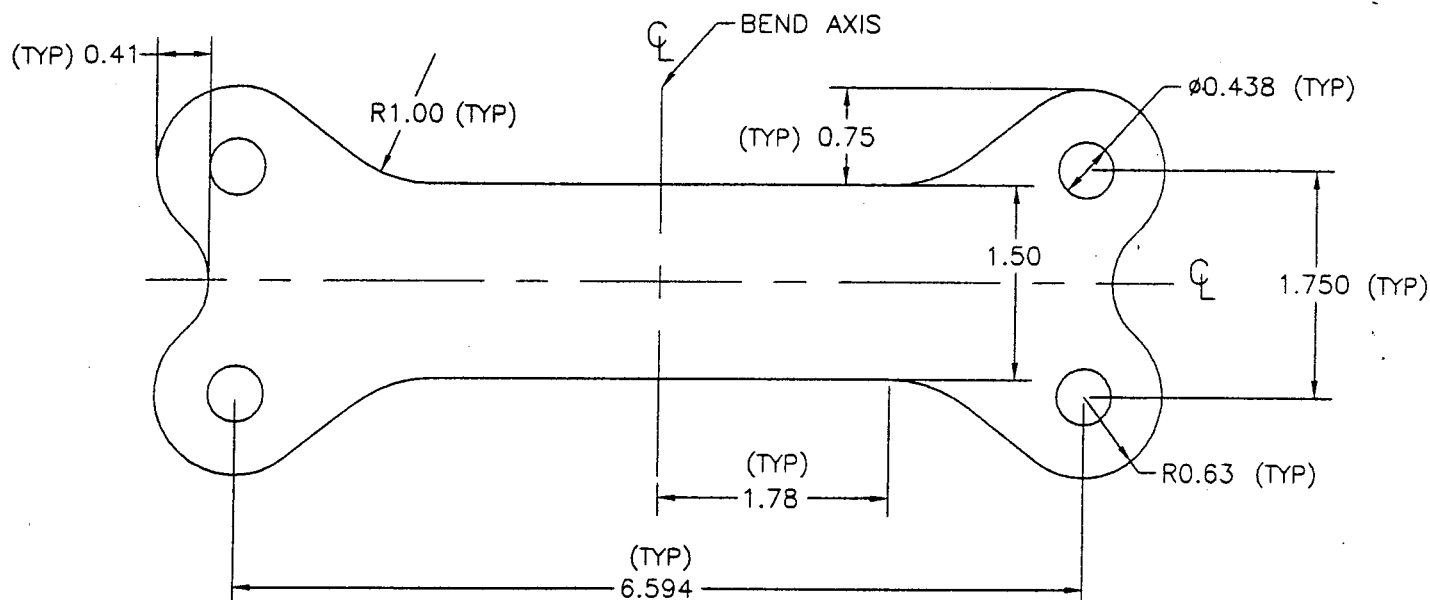
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

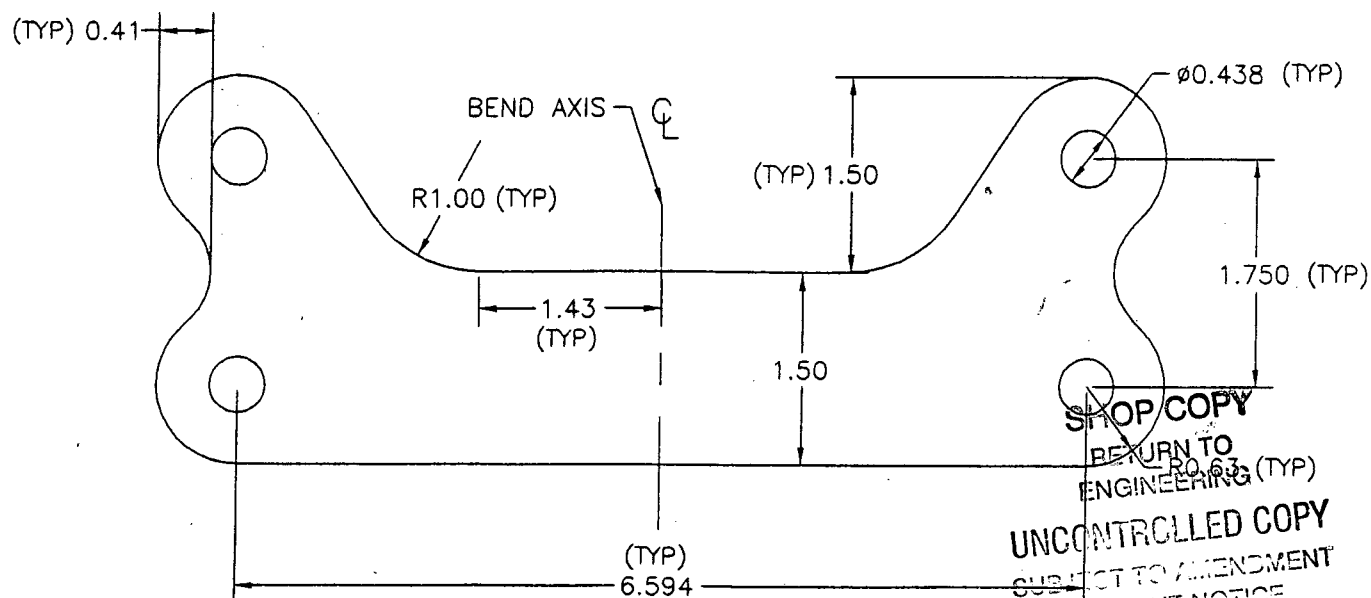


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



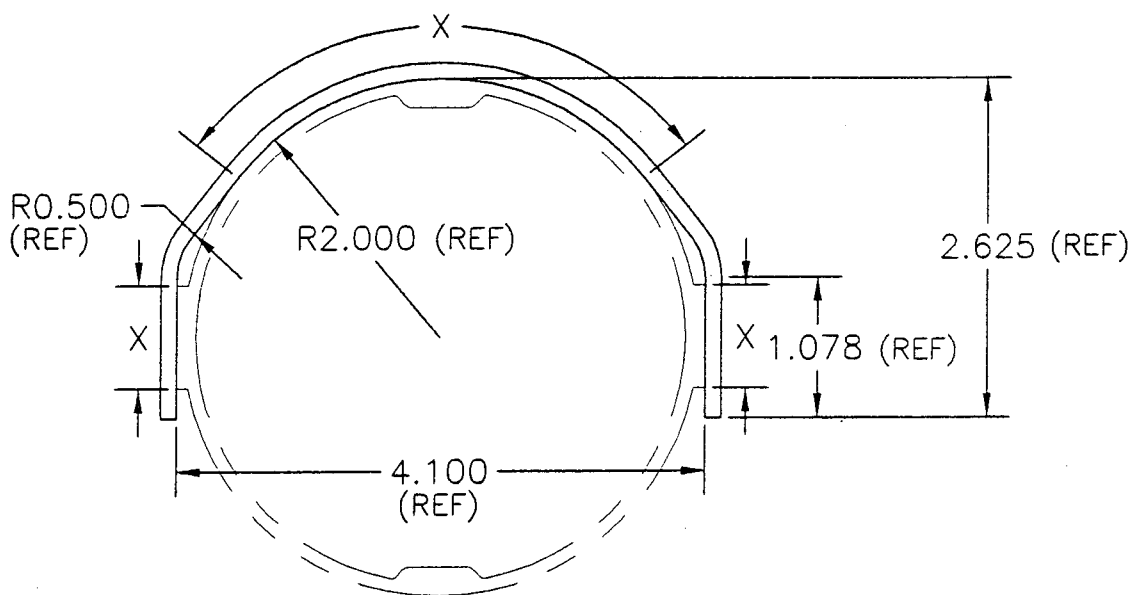
D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22009



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE) ✓
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 22009

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 01, 2004
07:31 am

Work Order No : 0022009
Project Name : D2735-1
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D2735-1
Description : Lug Bracket
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 11-30-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



BHP New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland 1, New Zealand
Telephones: (09) 3758 999 Auckland
(08) 2358 069 Waiuku
Fax: (09) 3758 959 Telex: 24936

TEST CERTIFICATE

Ref: 9852301

CUSTOMER	Wilkinson	P00821ME001										SPECIFICATION										ASTMA569										CERTIFICATE No										TC027066											
CUSTOMER O/N	90-31N-067										PRODUCT										HOT ROLLED PICKLED & OILED										PAGE										1 of 1												
MILL O/N	256321										DIMENSIONS										0.119" x 48" x Coil										DATE										22 November 2000												
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION -																ASTMA370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH																													
		x100				x1000										x10000		x100		180°				G.L.=		()	(feet)																										
HP-720792-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							820																												
HP-720793-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							827																												
HP-720794-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							817																												
HP-720795-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							830																												
HP-720796-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							807																												
HP-720797-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good							810																												

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 √ So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45) / 4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x (D)=2.5mm x	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Batish Misra
QC METALLURGIST